

ASAP.

Dart Aerospace Ltd.

Date: Tuesday, 12/18/2007 10:51:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 36423
 Estimate Number : 12737
 P.O. Number : N/A Part Number : D353513
 This Issue : 12/18/2007 S.O. No. : N/A Drawing Number : D3535 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 35562 Material : N/A
 Due Date : 1/15/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : 07.12.18
 Comment : Est Rev:A New Issue 07-02-15 JLM
 Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.8930 sf(s)/Unit Total : 17.8605 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 106702 B 8-1-7

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

B 8-1-7

2-Deburr if necessary B 8-1-7

20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-1-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

counts
 28/01/07 (+20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
 2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

S/B 08/01/08

08/01/08

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 28/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:51:22 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 36423

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08 (X20)

7.0

POWDER COATING

POWDER COATING



M105642



(20X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/01/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-09

(X20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P-17

JS

08-01-09

(X20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



U 08-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

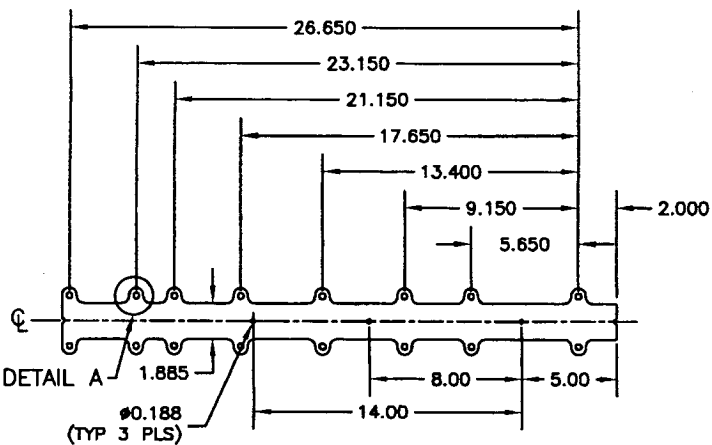
NOTE: Date & initial all entries

DART

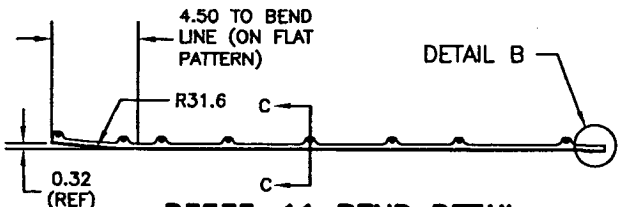
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07.04.24

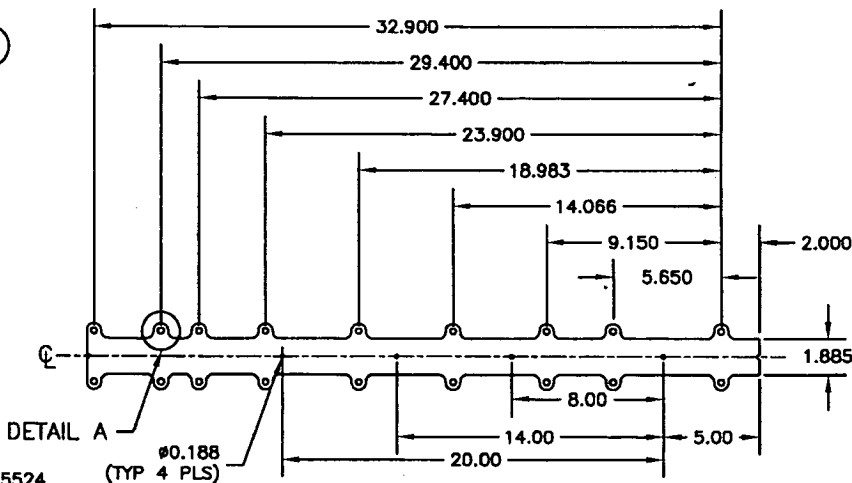
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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		



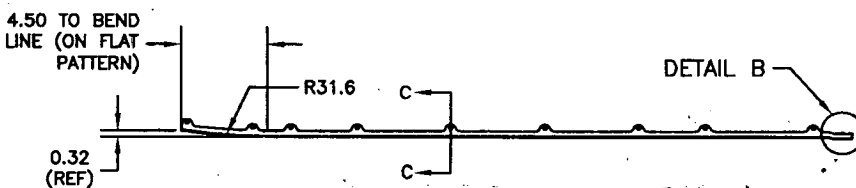
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

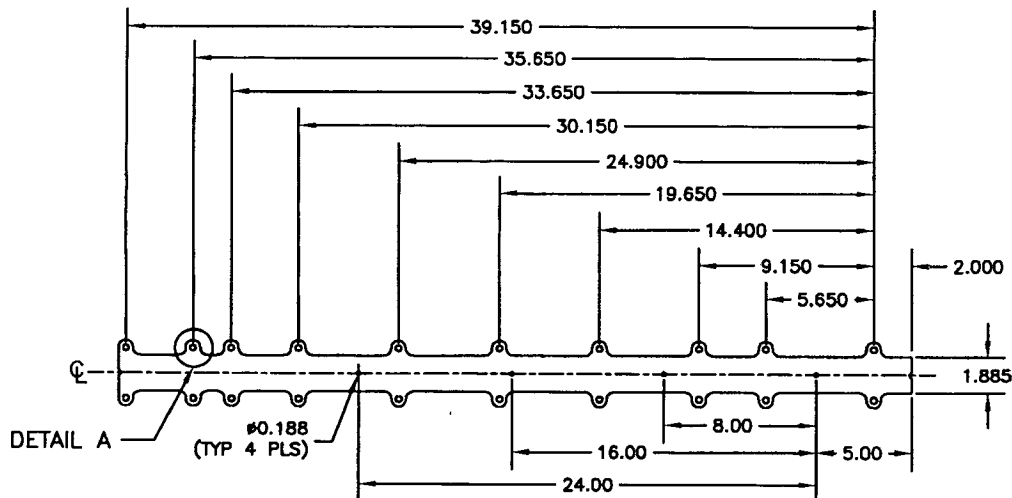
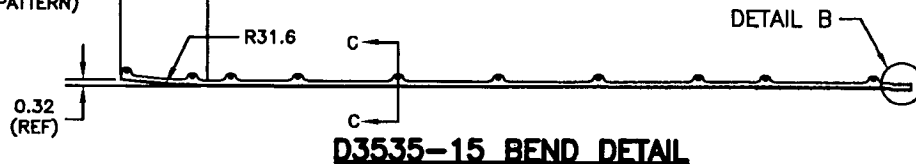
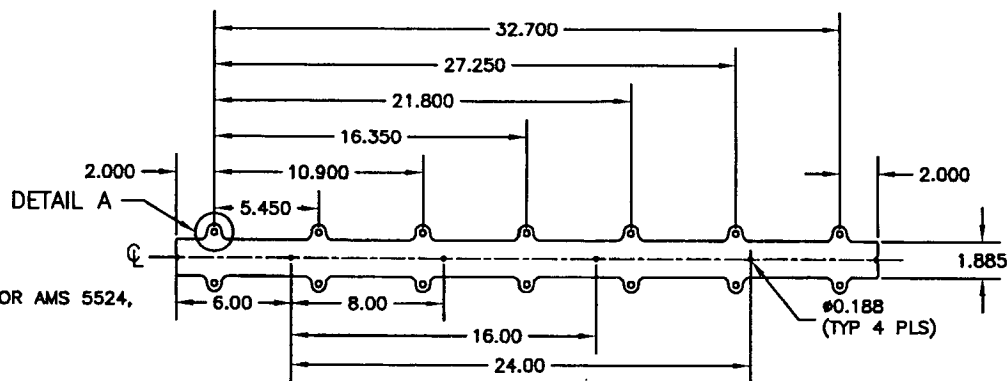
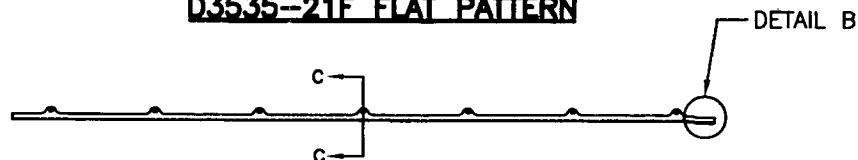
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WORK ORDER
NO. 36423

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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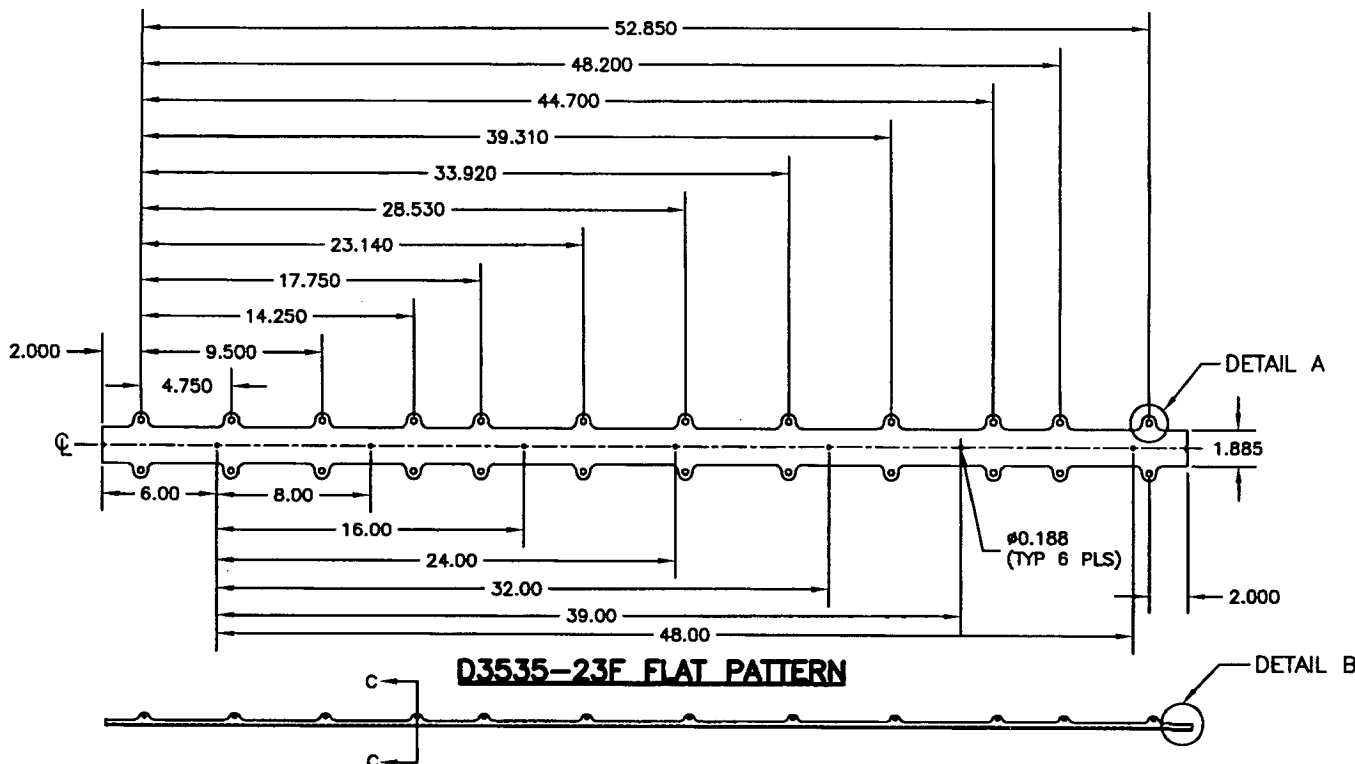
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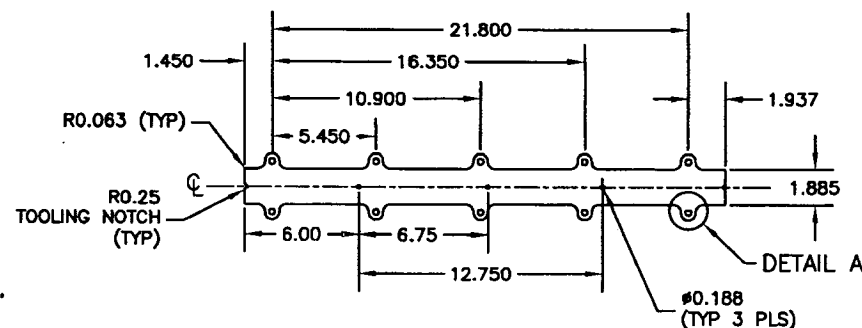
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CB	PH	PORT HADLOCK, WA
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#	#	D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE
		1:10



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

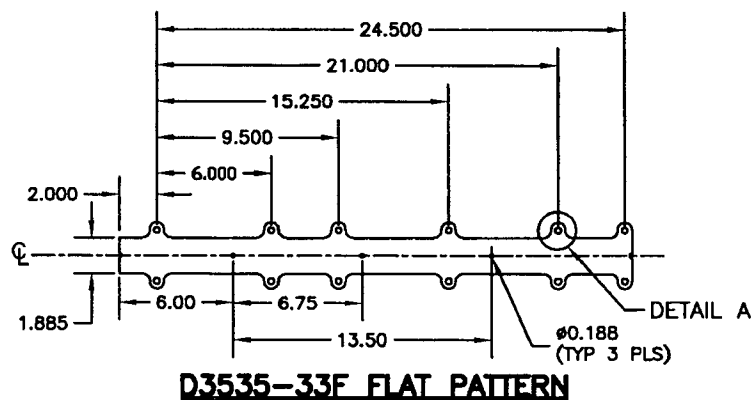
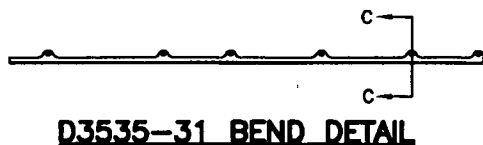
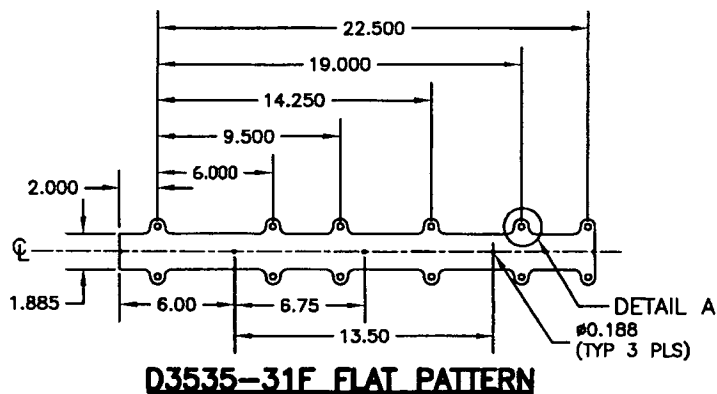
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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WORK ORDER
NO. 36423

NOTES

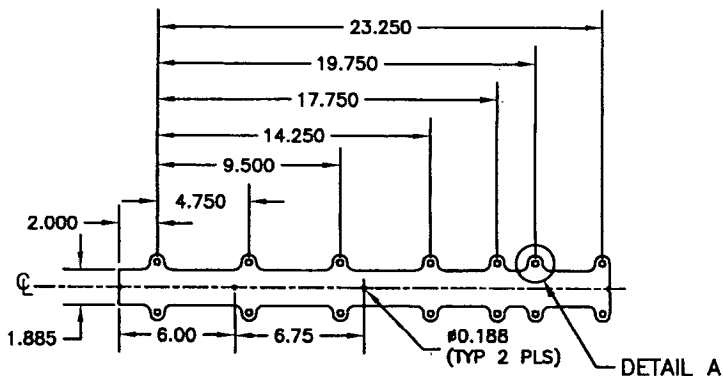
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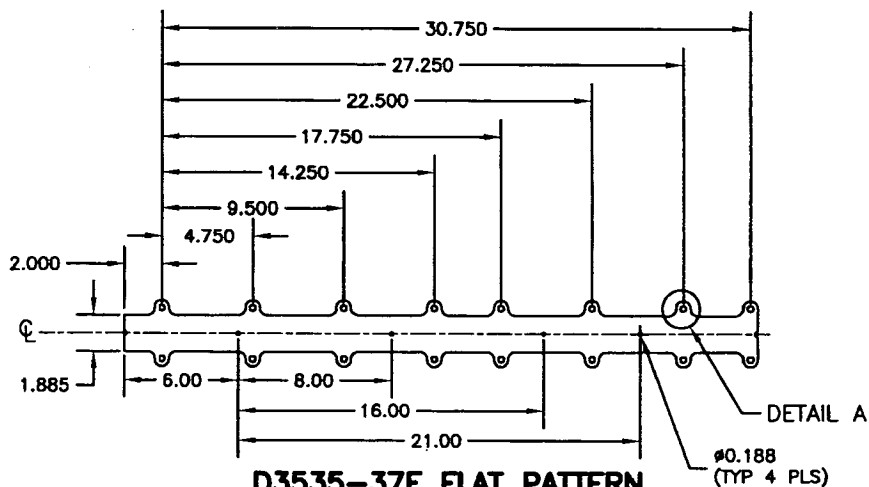
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

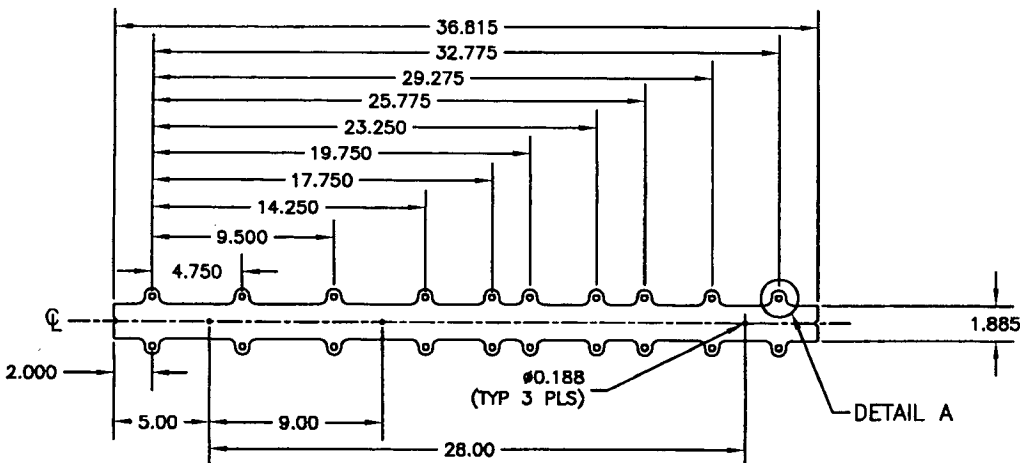
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DART

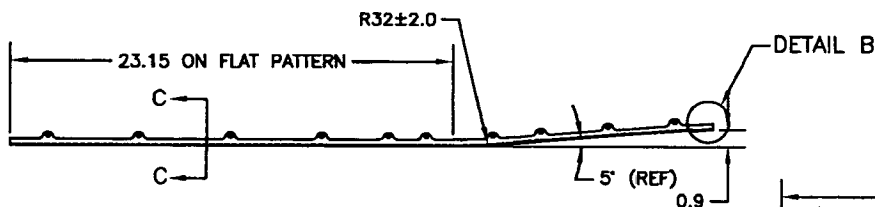
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



D3535-39F FLAT PATTERN

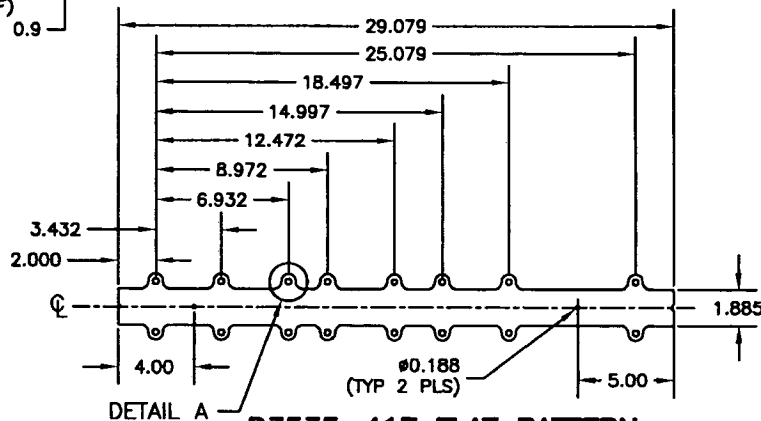


D3535-39 BEND DETAIL

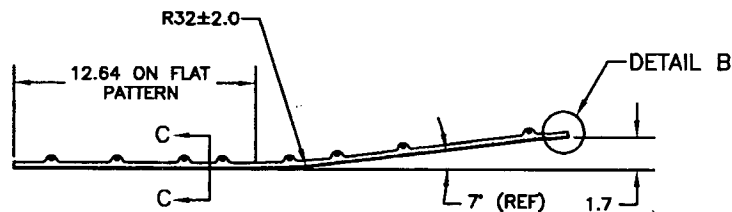
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WORK ORDER
NO. 36423

NOTES

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D3535-41F FLAT PATTERN

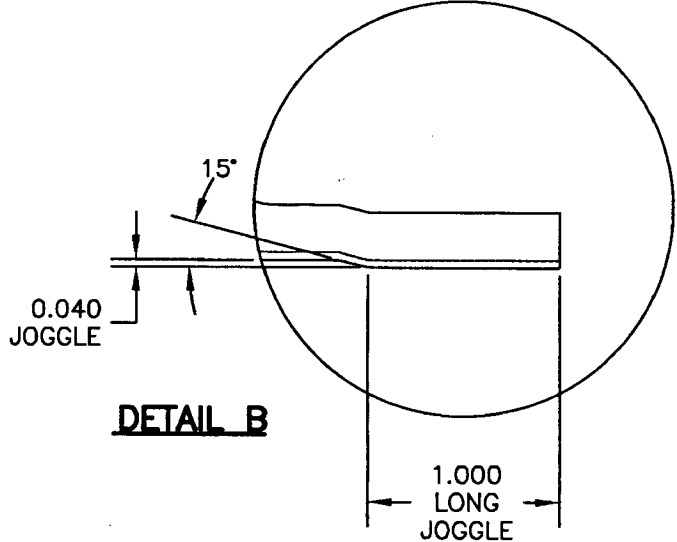


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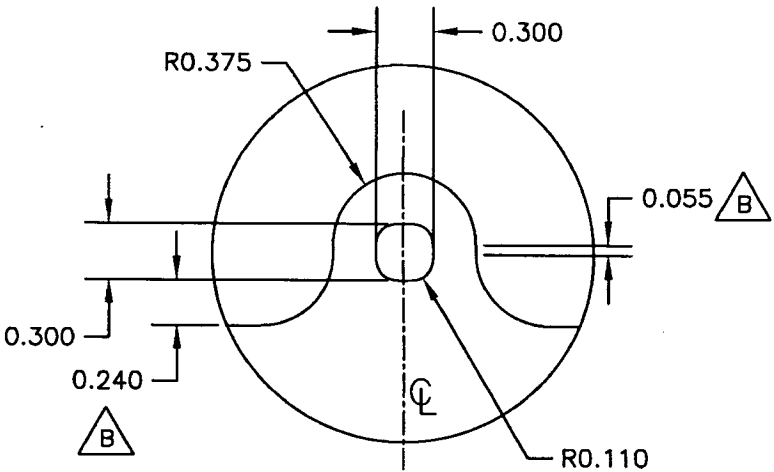


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				PORT HADLOCK, WA
CHECKED		APPROVED		DRAWING NO. D3535
DATE	07.04.17			REV. B
				SHEET 7 OF 7
				SCALE 1:1
				TITLE WEARSHOE

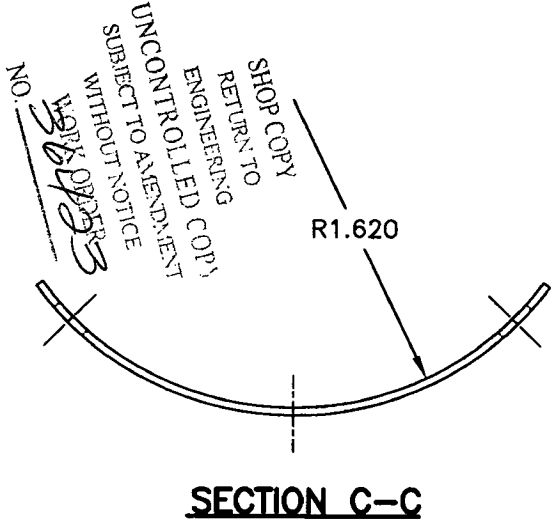
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DETAIL B



DETAIL A



SECTION C-C


DART AEROSPACE LTD		Work Order: 36423
Description: WEAR SHOE		Part Number: D3535-13
Inspection Dwg: 3535-13 Rev: B		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.190	X			
.300	± .010	.304	X			
.300	± .010	.304	X			
1.885	± .010	1.888	X			
2.000	± .010	2.000	X			
5.000	± .030	5.00	X			
5.650	± .010	5.650	X			
8.00	± .030	8.00	X			
14.00	± .030	14.00	X			
20.00	± .030	20.00	X			
9.150	± .010	9.150	X			
14.066	± .010	14.066	X			
18.983	± .010	18.983	X			
23.900	± .010	23.900	X			
27.400	± .010	27.400	X			
29.400	± .010	29.400	X			
32.900	± .010	32.900	X			

Measured by: B
Date: 8-1-7

Audited by: 
Date: 08/01/07

Prototype Approval: 
Date: 8/1/7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

